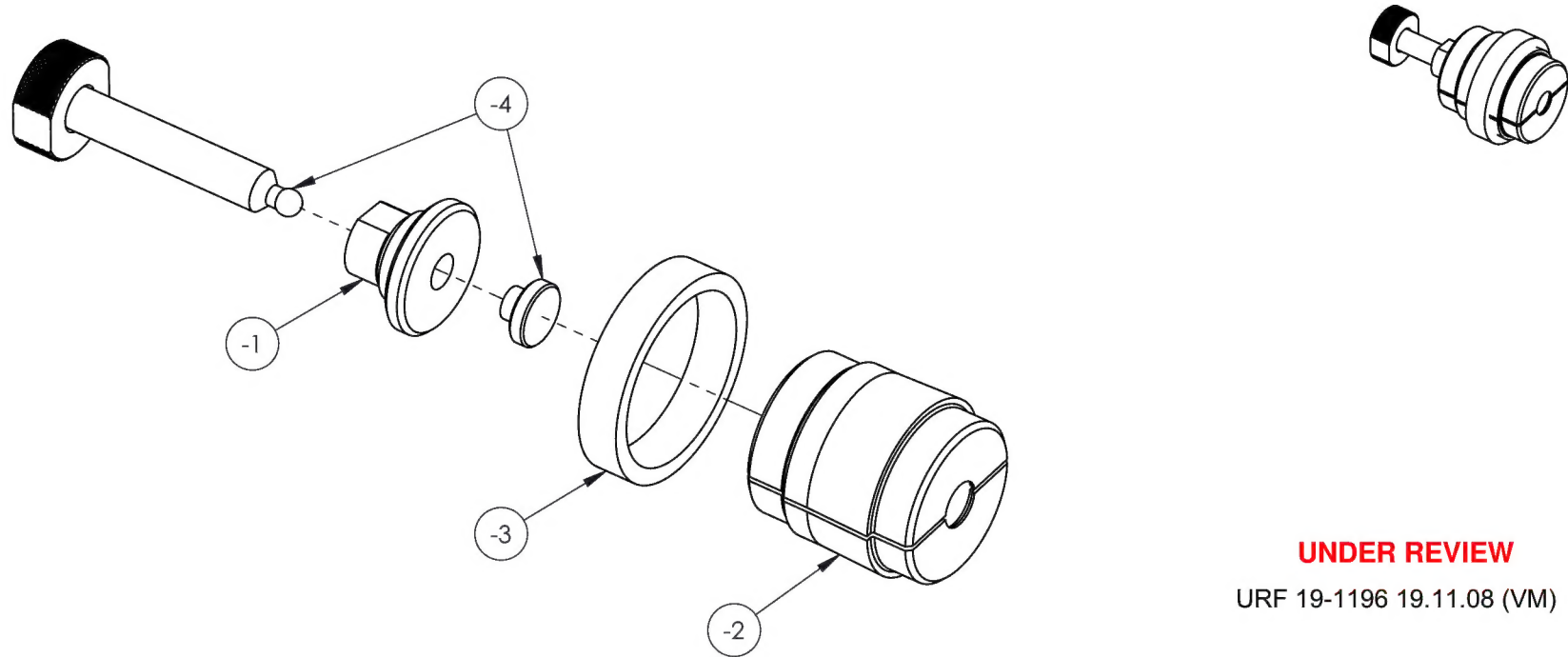


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	15-0204	-2 CH'D MATERIAL WAS 4340 IS 4140/4142, ADDED PART MARK MATCHING PIECES.	8/11/2015	RJC	JAG



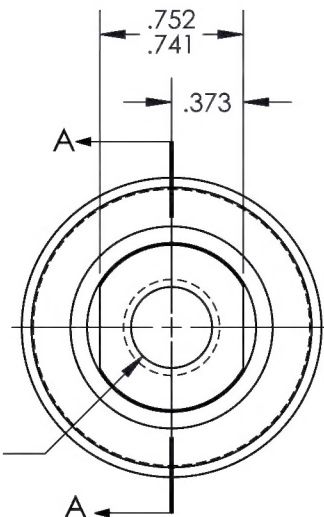
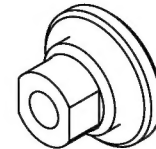
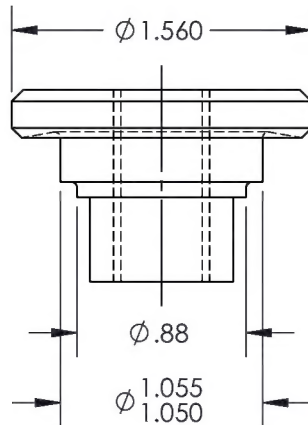
NOTE:  
REF. ROLLS ROYCE T/N 23005023.

<b>DART</b> AEROSPACE	
TITLE PULLER-BEARING AND SEAL RING, FRONT COMPRESSOR	
DWG NO. RB23005023	REV 1
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .02 ANGLES ± 1°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 8/11/2015
SHEET 1 OF 5	

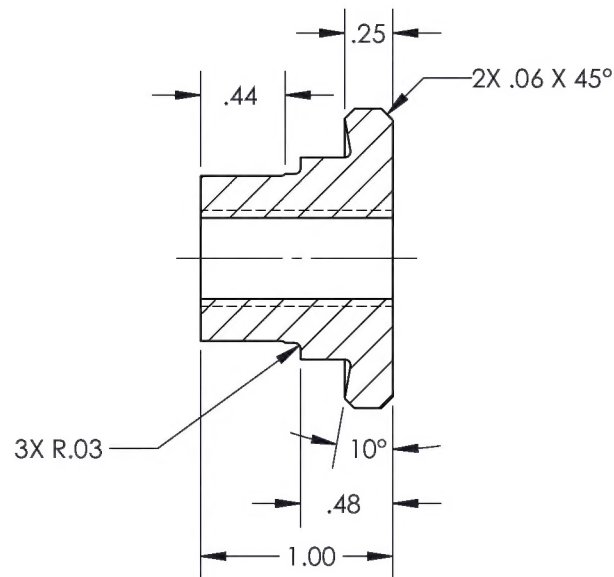
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SUPPORT	1018/1020		2
			-2	1	DOG	4140/4142		3
			-3	1	RING	1018/1020		4
			-4	1	SWIVEL HEAD SCREW	STEEL	1/2-13 UNC X 3-1/16 CARR-LANE #CL-29-SHS MODIFIED	5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



1/2-13 UNC - 2B  
THRU ALL



SECTION A-A

(1)

SUPPORT

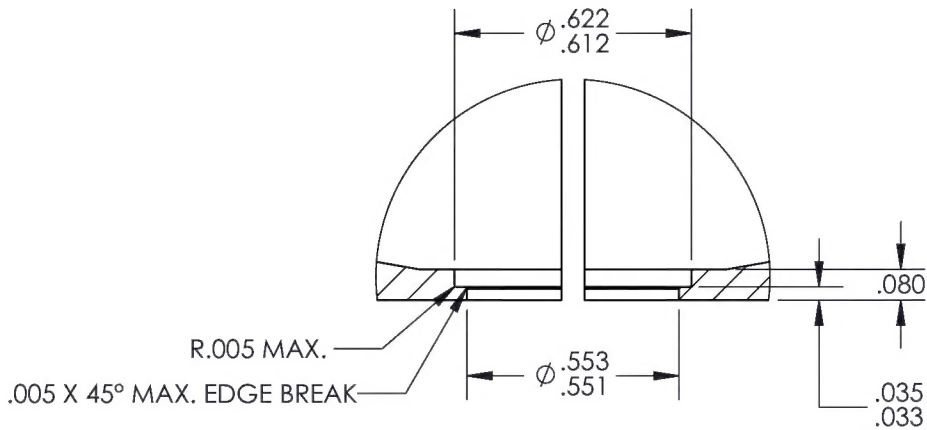
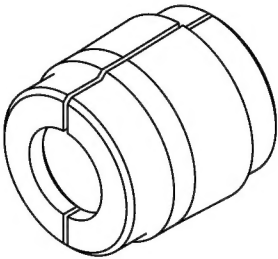
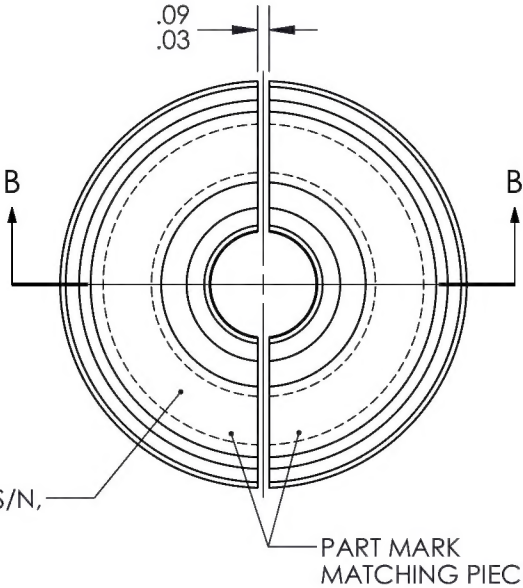
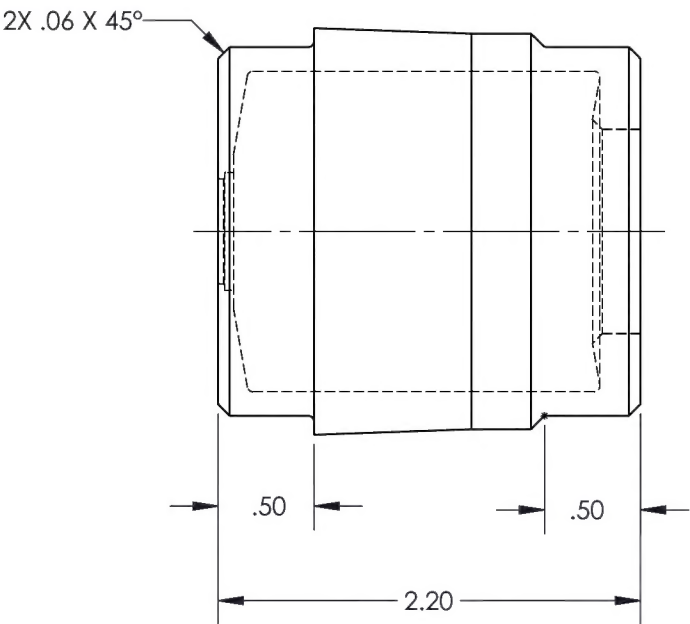
**UNDER REVIEW**

URF 19-1196 19.11.08 (VM)

<b>DART AEROSPACE</b>	
TITLE PULLER-BEARING AND SEAL RING, FRONT COMPRESSOR	
DWG NO. RB23005023-1	REV 1
MAT'L 1018/1020	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .02 ANGLES ± 1°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/11/2015
SHEET 2 OF 5	

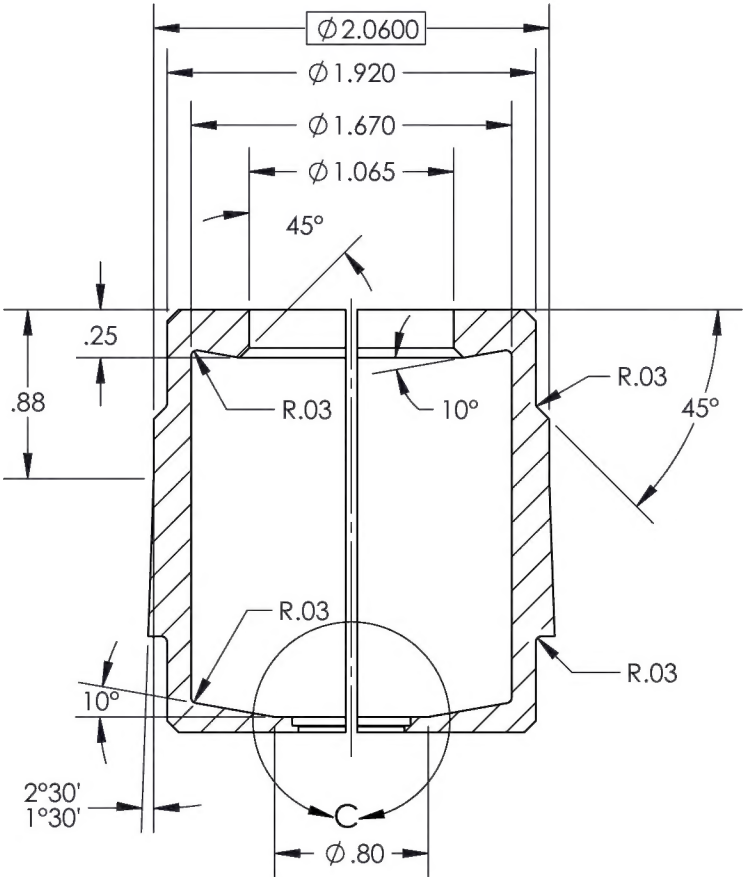
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1	15-0204	-2 CH'D MATERIAL WAS 4340 IS 4140/4142, ADDED PART MARK MATCHING PIECES.	8/11/2015	RJC
				APPROVED
				JAG



DETAIL C

(-2)  
DOG



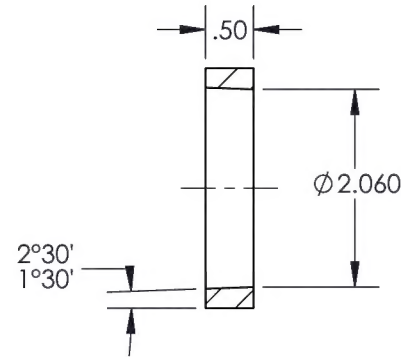
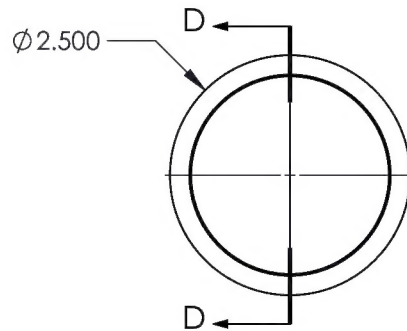
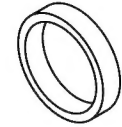
SECTION B-B

**UNDER REVIEW**  
URF 19-1196 19.11.08 (VM)

<b>DART</b> AEROSPACE		
TITLE PULLER-BEARING AND SEAL RING, FRONT COMPRESSOR		
DWG NO.	RB23005023-2	REV 1
MAT'L 4140/4142	DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>J. Gilbert</i>	
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT RC 36-40	
.XX ± .02 ANGLES ± 1°	FINISH BLACK OXIDE	
.X ± .1	SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE 1:1	DATE 8/11/2015	SHEET 3 OF 5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION D-D

**UNDER REVIEW**

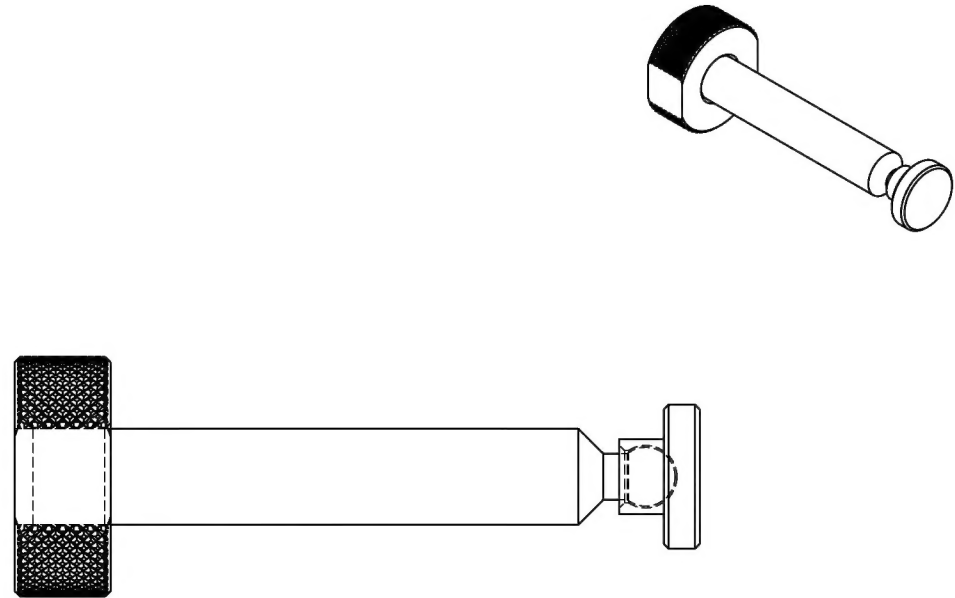
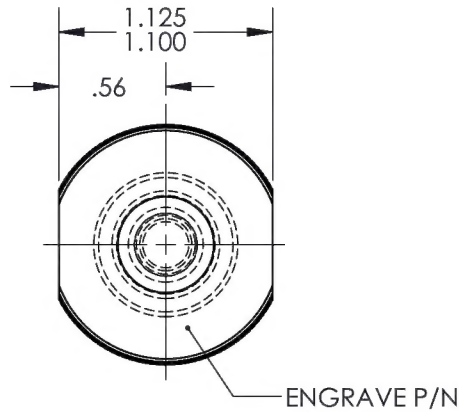
URF 19-1196 19.11.08 (VM)

③  
RING

<b>DART AEROSPACE</b>	
TITLE PULLER-BEARING AND SEAL RING, FRONT COMPRESSOR	
DWG NO. RB23005023-3	REV 1
MAT'L 1018/1020	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .02 ANGLES ± 1°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/11/2015
SHEET 4 OF 5	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



**UNDER REVIEW**

URF 19-1196 19.11.08 (VM)

(-4)  
SWIVEL HEAD SCREW

<b>DART AEROSPACE</b>	
TITLE PULLER-BEARING AND SEAL RING, FRONT COMPRESSOR	
DWG NO. RB23005023-4	REV 1
MAT'L STEEL	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .02 ANGLES ± 1°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/11/2015
SHEET 5 OF 5	